Date:

Thursday, 4/12/2007 8:22:20 AM

User

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 31660

: 10425

P.O. Number

: NIA

: 4/12/2007 This Issue

: 31343

S.O. No. : NA

Type

: SMALL /MED FAB

Drawing Number Project Number

Drawing Revision

Drawing Name

Part Number

Material **Due Date** . D3219 REV A : N/A

: D32191

: PLATE

: NIA : 4/22/2007

Qty:

60 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

New issue KJ/JLM

: Est.

ESR B 06.05.25 Waterjet

Additional Product

Job Number:



Seq. #:

Description:

1.0

M6061T6S125

6061-T6 .125 Sheet

Comment: Qty.:

0.1012 sf(s)/Unit

Total:

6.0732 sf(s)

6061-T6 .125 Sheet

To be made in multiples of 4

Material: 6061-T6 (QQ-A-200/11) 0.125" thick

(M6061T6S.125) Batch: MO3156

2.0

WATER JET



FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3219

Prog Rev:_

07 05 11

3.0

QC2

EQOND CHECK



0705 15



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8





5.0

Comment: SECOND CHECK SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

ME

07-05-20



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				···.					
Part No	:	PAR #: Fault Category:	NCR: Yes	No) DQ	A: =7	Date: C	7106/01		

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B		Verification	Annroval	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng		
							<u>.</u>		

NOTE: Date & initial all entries

Thursday, 4/12/2007 8:22:20 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: PLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D32191 Job Number: 31660 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP QC5 6.0 6 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location WH FINAL INSPECTION/W/O RELEASE QC21 8.0 67/06/01 Comment: FINAL INSPECTION/W/O RELEASE Job Completion W Broke 6/

Dart Ae	rospace	e Ltd							
W/O:		· · · · · · · · · · · · · · · · · · ·	WC	RK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date:	<u> </u>
					QA: N	I/C Closed	:	_ Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)			
		Description of NC		Corrective Action Section		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31660
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X		First Article	Prototype
	\neg		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	0.316	1	-1,-	VERN	
2.293	+/-0.005	2.293	1		JUN	
2.965	+/-0.010	2.966			vern	
0.566	+/-0.010	0.565	V,	•	VENN	
0.375	+/-0.010	0.379	V		vern	
R0.125	+/-0.010	RO. 175	/		R.G	
0.125	+/-0.010	0.120	/		vern	
13.9	+/-0.010	13.9	1		A-M	

Measured by:	m.m	Audited by:	Prototype Approval:	N/A
Date:	07 05 15	Date:	Date:	N/A

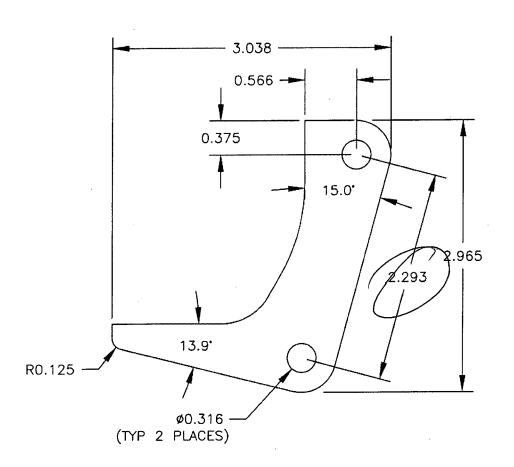
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue	KJ/JLM 🛠	





DESIG	n ap	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECH	KED ,	APPROVED,	DRAWING NO.	REV. A		
	#	#	D3219	SHEET 1 OF 1		
DATE			TITLE	SCALE		
03.1	0.10	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	PLATE	1:1		
Α		03.10.10	NEW ISSUE			





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11) (REF_DART_SPEC_M6061T6S.125)
- 3) FINISH: NONE
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

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